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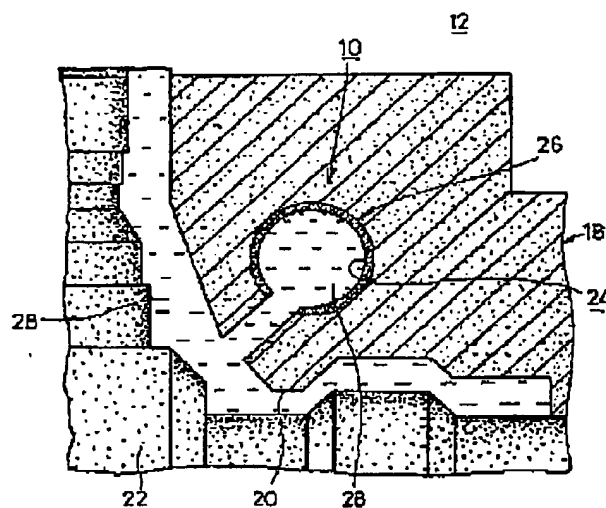
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TITLE : STRUCTURE OF FEEDER HEAD IN
METALLIC MOLD FOR CASTING



ABSTRACT : PROBLEM TO BE SOLVED: To set the capacity of a feeder head to the absolute minimum with a simple constitution and to surely replenish molten metal into a cavity by arranging a heat-insulating part having smaller porous ratio than that of a porous metallic mold at the surroundings of the feeder head.

SOLUTION: The structure 10 of the feeder head part has the feeder head part 24 having a prescribed capacity as a non-product part communicated with the cavity 20 and in the surroundings, the heat-insulating part 26 is arranged. The heat-insulating part 26 is set to have a porous ratio smaller than that of a sliding mold 18 and e.g. in the case of 17-25 vol.% of the porous ratio of the sliding mold 18, this heat-insulating part has a porous ratio of ≤ 17 vol.%. Thus, the flowing of the air from the heat-insulating part 26 is regulated and the heat-insulation is effectively improved in comparison with the sliding mold 18. Therefore, the solidification of molten metal 28 in the feeder head part 24 can be delayed and the solidify-shrinking part of the molten metal 28 in the cavity 20 can surely be replenished with the molten metal 28 in this feeder head part 24. Further, the heat insulating part, by using a high strength member therefore, can resist the thermal stress caused by the molten metal 28 filled in the feeder head part 24.

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